

**Work Order ID 52203**

September 17, 2009 1:55:45 PM



Page 1

Item ID: D3140-91

Revision ID: F

Item Name: Doubler

Start Date: 9/17/09 Start Qty: 4.00

Required Date: 9/18/09 Req'd Qty: 4.00

*Split*

Accept



Setup Start



Stop



Reference:

Approvals: Process Plan:

*(L)*

Date:

Tooling:

Date:

Run Start



QC:

Date: 09/09/17

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
Description

Draw Nbr

Revision Nbr

D3140

Rev F

100



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D3140: \*\*ENSURE THAT GRAIN DIRECTION IS  
CORRECT\*\*\* Dwg Rev: *F* Prog Rev: *F* 2-Deburr if  
necessary*HB 9-9-17**(6)*

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

*HB 4-9-17*

Quality Control

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

*→ S 01/18*

Quality Control

*(46) f*

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Page 2

Item ID: D3140-91

Accept



Setup Start



Revision ID: F

Stop



Item Name: Doubler

Start Date: 9/17/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Form as per Dwg D3140  
2-Scuff surfaces with 80grit sandpaper per  
QSI 006  
3-Deburr.  
No sharp edges

SB 09/09/18

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

=&gt; SB 09/09/18

(X)

f

150



Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

MD 09/09/18

(X)

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Item ID: D3140-91

Accept



Setup Start



Revision ID: F

Stop



Item Name: Doubler

Start Date: 9/17/09 Start Qty: 4.00



Cust Item ID:

Required Date: 9/18/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

09/09/18

0.00

0

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

9/9/18 QD SP

Memo

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/09/12 AD

MF 09-09-18

# Picklist Print

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Page 1

Work Order ID: 52203



Parent Item: D3140-91RevF



Parent Item Name: Doubler

Start Date: 9/17/09

Required Date: 9/18/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No		100	sf	96.7095	0.6211	.9316		

2024-T3 .032 sheet

## Warehouse

## Location

### Main Warehouse

MAT 96.70953158

102942	1.5	
105555	5	105555
106272	5.3	
108595	3	
109240	7.02	
110778	23.9106316	
111699	47.9789	
18147	3	

## Loc Qty

## Loc Code

1B9-9-17

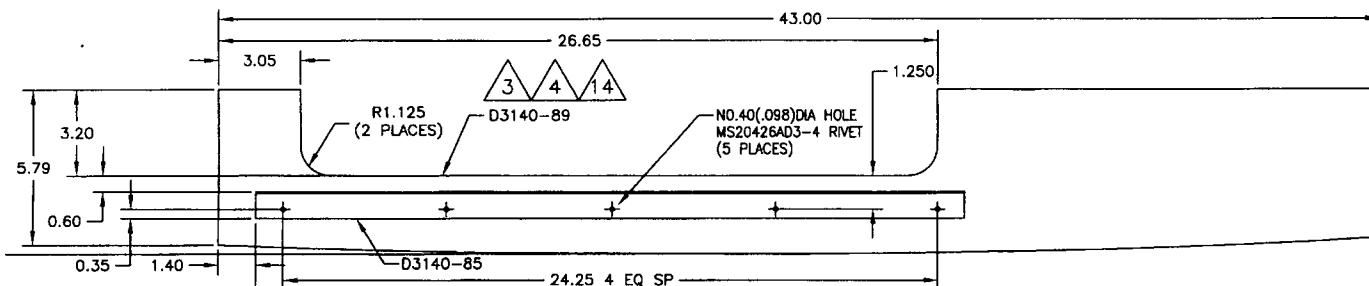
DART AEROSPACE LTD	Work Order:	52203
Description: Doubler	Part Number:	D3140-91
Inspection Dwg: D3140-91 Rev: F		Page 1 of 1

## **FIRST ARTICLE INSPECTION CHECKLIST**

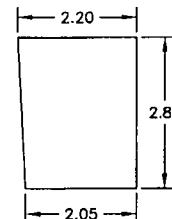
## X First Article      Prototype

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	9-9-17	Date:	07/05/18	Date:	N/A

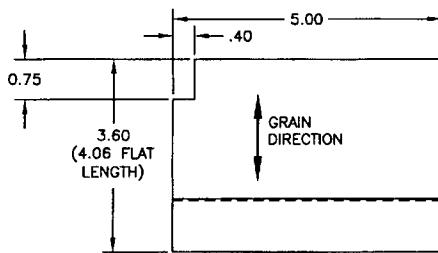
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



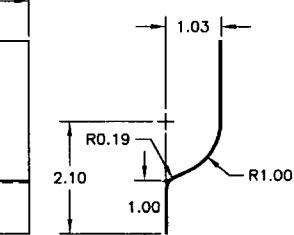
**D3140-09 DOUBLER ASSEMBLY** (SHOWN, REPLACES PREMIER P/N B30-23000-09)  
**D3140-10 DOUBLER ASSEMBLY** (OPPOSITE, REPLACES PREMIER P/N B30-23000-10)



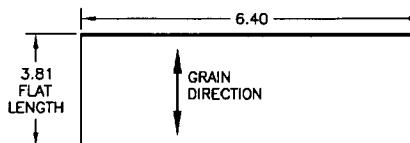
**D3140-101 DOUBLER** 4 14  
 (REPLACES PREMIER P/N B30-23000-101)



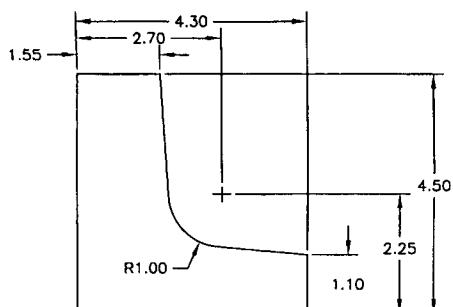
**D3140-91F DOUBLER**  
 (USE TO MAKE D3140-91/-92 DOUBLERS)



**D3140-92 DOUBLER** 4 14 F  
 (SHOWN, REPLACES PREMIER P/N B30-23000-92)  
**D3140-91 DOUBLER**  
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-91)



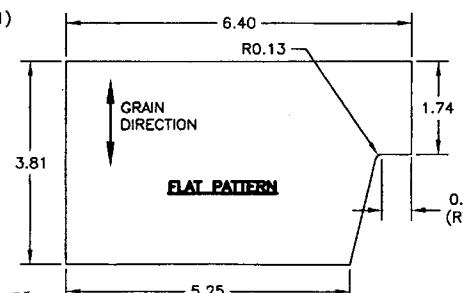
**D3140-95 DOUBLER** 4 14  
 (REPLACES PREMIER P/N B30-23000-95)



**D3140-99 DOUBLER** 4 14  
 (REPLACES PREMIER P/N B30-23000-99)

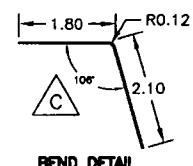
SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 52203

**D3140-97F Flat Pattern**  
 (USE TO MAKE D3140-97/-98 DOUBLERS)



**D3140-97 DOUBLER** 4 14  
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)  
**D3140-98 DOUBLER**  
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

RELEASED  
 06/11/03



**BEND DETAIL**

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DESIGN

4

DRAWN BY

CB

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CB

DART

DART AEROSPACE LTD.  
 HAMPSHIRE, ONTARIO, CANADA

REV. F

DRAWING NO.

D3140

DATE

06.10.06

TITLE

DOOR

SHEET 5 OF 7

SCALE

NTS